

Work Order ID: 60141

Monday, June 28, 2010 7:38:27 AM

Page 1

Item ID: D3067-1

Accept

Setup Start

Revision ID:

Stop

Item Name: End Plate

Start Date: 6/28/2010 Start Qty: 160.00

Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 160.00

Customer:

Reference:

Run Start

Approvals: Process Plan: MLT Date: 10-6-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3067

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3067 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 12-

Deburr if necessary

5052.063

Deburr = 7 m. l w/06/30

(165X)

(165)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/30

counted
(165)

QSP015

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3067

0.00

0.00

SB 10/27/05

165

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/05

165

150



Packaging

Packaging

Identify as per dwg & Stock Location: W4

Memo

0.00

0.00

SL 10.07.22

165

W/O:		WORK ORDER CHANGES					
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Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 6/28/2010 Start Qty: 160.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23
MF
10-7-23

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Picklist Print

Monday, June 28, 2010 7:38:26 AM

Page 1

Work Order ID: 60141



Parent Item: D3067-1



Parent Item Name: End Plate

Start Date: 6/28/2010

Required Date: 7/2/2010

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ ☐
IPP Rev:B Now on Water jet 06-06-16 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

209.1700

0.0625

10.52632



5052-H32 .063 Sheet



1310-6-29

Location

Loc Qty

Loc Code

MAT

192

114322

192

MAT22

17.17

112442

17.17

112442

168

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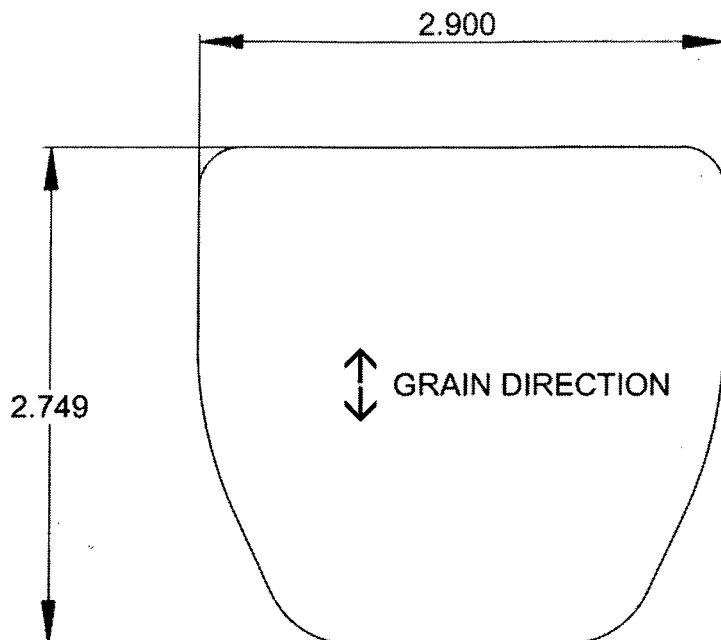
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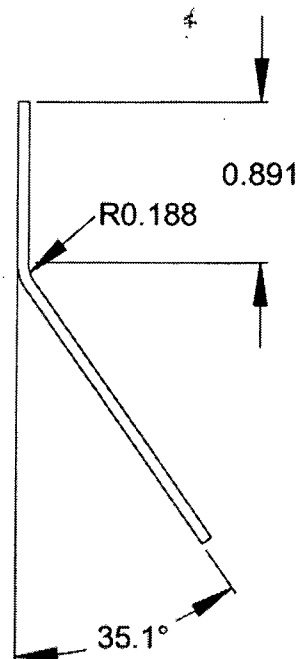


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1-END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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